Date:

Thursday, 10/25/2007 10:12:27 AM

User:

Process Sheet

Drawing Name

Part Number

Material Due Date

Drawing Number

Project Number

Drawing Revision

Customer

Job Number

: CU-DAR001 Dart Helicopters Services

: 35367 : 10332 **Estimate Number**

P.O. Number

This Issue

: 10/25/2007

Prsht Rev. First Issue

Previous Run

: NC

: 11

S.O. No. :

: SMALL /MED FAB Type

: 33990

Written By Checked & Approved By

Comment

: Est Rev:A

New Issue

05-11-07

Est Rev:B Now on Waterjet 06-06-20 JLM

JLM

: 11/2/2007

: LOCK PLATE

. D2534 REV D

: D2534

: N/A

; D

Qty:

30 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

304/316 .125 Sheet

1.0

M304S11GA

Comment: Qtv.:

0.0448 sf(s)/Unit

Total:

1.3451 sf(s)

304/316 .125 Sheet (M304S11GA)

2.0



Comment: FLOW WATER JET

1-Cut as per Dwg D2734 Dwg Rev: D

Prog Rev:____

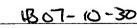
IR 07-10-30



2-Deburr if necessary

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PAT Duval

Dart Aerospace Ltd	D	art	Aer	osp	ace	Ltd
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Dant Ac	ospace	F Lla							
W/O:			WC	RK ORDER CHANGES	3				
DATE	STEP	PR	OCEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•							
		4							
		os ·							:
Part No		PAR #:	Fault Cated	iorv:	NCR: Yes	No DQA	•	Date:	
								Date: _	
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCR)			
D.4.T.E.	OTED	Description of NC	Corrective Action Section B			Verifica	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Date:

Thursday, 10/25/2007 10:12:28 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOCK PLATE

Job Number: 35367

Part Number: D2534

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



a Stilled

Dart Ae	rospace	e Ltd						
W /O:			WC	ORK ORDER CHANGE	ES			
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA:	Date: _	
					QA: N/	C Closed:	Date: _	
NCR:		÷	WORK ORDI	R NON-CONFORMA	NCE (NCR)	·	
DATE	OTED	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
		1.03						

		Description of NC	Description of NC Corrective Action Section B				A		
DATE	STEP	Description of NC Section A	Initial Action Description Sign & Chief Eng Date		- Verification Section C	Approval Chief Eng	Approval QC Inspector		
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35367
Description: Lock Plate	Part Number:	D2534
Inspection Dwg: D2534 Rev: D		Page 1 of 1

	X	First Artic	cle	_ Proto	type	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.447	+0.006/-0.001	,448	*			
R0.500	+/-0.010	1500	*			
R0.173	+/-0.010	٤٢١،	×			
R0.096	+/-0.010	1096	8≠			
R0.125	+/-0.010	1192	×			
R0.120	+/-0.010	٥٤١,	3			
R0.200	+/-0.010	1960	*			
0.125	+/-0.010	. 121	4			

Measured by: 🔏	Audited by:	co	Prototype Approval:	N/A
Date: 07-10-36	Date:	4/6/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.03.14	New Issue	KJ/JLM	
				7-7-

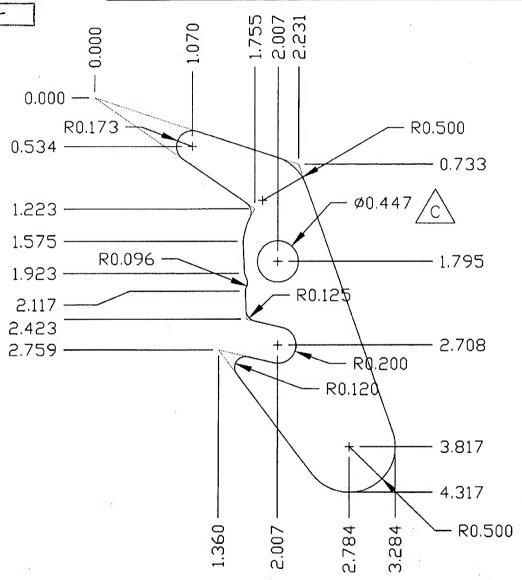
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DESIG	N	DRAWN BY	DART AEROSPACE LTD	
B W	ILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHEC	KED MA	APPROVED	DRAWING NO.	REV. D
	-##-	#	D2534 SHEET	1 OF 1
DATE			TITLE	SCALE
04.1	2.14		LOCK PLATE	1:1
С		96.07.26	HOLE WAS 0.328	
n		04 12 14	UPDATE NOTES	

RELEASED 04.12.16



D2534 LOCK PLATE

AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK)

ENGINEERING (REF. DART SPEC. M304S11GA)

2) FINISH: NONE

3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

RETURN TO

UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE